

84806

Page 1

N900040100

Setup Start *NS1*

Stop *NS2*

4

Cust Item ID:

4

Customer:

Reference:

Date: 12/05/22 Tooling:

Date:

Run Start *NR1*

QC:

Date: **SPC (Y/N):**

Date:

Stop *NR2*

Draw Nbr	Revision Nbr	
N/A	Rev N/A	KSP

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy blue file and type labels as per PPP D206-628-012 CHG 003

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.00

Quality Control

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 84806

May-23-12 11:32:31 AM

84806

Page 2

Item ID: D206-628-012

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Heli-Access-Step RH

Start Date: 23/05/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 06/06/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00				4x			SP
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D206-628-012 Location: _____ PPP Rev: <u>F</u>								12-7-10
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							CK 12/7/11
Quality Control									

12-7-11

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 1

May-23-12 11:32:35 AM

Work Order ID: 84806

84806

Parent Item: D206-628-012

D206-628-012

Parent Item Name: Heli-Access-Step RH

Start Date: 23/05/2012

Required Date: 06/06/2012

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP Rev:D As Per Ecn 766 06-01-06 JLM
 IPP rev E changed D2731-1 to D2731-3 EC
 IPP Rev:F as per ecn 1118 08-02-05 DD verified by:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status																		
D2721-042		Manufactured	No			110	Each	0.0000	1	4																					
<div><div>*D2721-042*</div><div>206B Step Assembly</div></div>																															
D2731-7		Manufactured	No			110	Each	72.0000	4	16																					
<div><div>*D2731-7*</div><div>Mounting Lug</div></div>																															
<table><tr><th>Location</th><th>Loc Qty</th><th>Loc Code</th></tr><tr><td>ST</td><td>-50</td><td></td></tr><tr><td>ST468A</td><td>4</td><td></td></tr><tr><td>71860</td><td>4</td><td></td></tr><tr><td>ST469</td><td>118</td><td></td></tr><tr><td>78922</td><td>68</td><td></td></tr></table>														Location	Loc Qty	Loc Code	ST	-50		ST468A	4		71860	4		ST469	118		78922	68	
Location	Loc Qty	Loc Code																													
ST	-50																														
ST468A	4																														
71860	4																														
ST469	118																														
78922	68																														
D2732-030		Manufactured	No			110	Each	2.0000	8	32																					
<div><div>*D2732-030*</div><div>Rubber Cushion</div></div>																															
<table><tr><th>Location</th><th>Loc Qty</th><th>Loc Code</th></tr><tr><td>ST402</td><td>2</td><td></td></tr><tr><td>76850</td><td>1</td><td></td></tr><tr><td>81499</td><td>1</td><td></td></tr></table>														Location	Loc Qty	Loc Code	ST402	2		76850	1		81499	1							
Location	Loc Qty	Loc Code																													
ST402	2																														
76850	1																														
81499	1																														

S.M. ***D2732-030***

Rubber Cushion

on 88 per kit
3.011 → measure
8/17/06

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

May-23-12 11:32:35 AM

Page 2

Work Order ID: 84806

84806

Parent Item: D206-628-012

D206-628-012

Parent Item Name: Heli-Access-Step RH

Start Date: 23/05/2012

Required Date: 06/06/2012

Start Qty: 4.00

Required Qty: 4.00

D3394-043

Manufactured No

110 Each

112.0000 4 16

D3394-043

Lug Assembly

**

JB

Location

Loc Qty

Loc Code

ST479

112

78921

32

80217

60

82760

20

78921

AN4-13A

Purchased No

110 Each

1,513.000 4 16

AN4-13A

Bolt

**

JB

Location

Loc Qty

Loc Code

ST357

1513

119449

33

120187

19

120422

2

120770

394

121162

65

121652

1000

121652

AN4-14A

Purchased No

110 Each

344.0000 4 16

AN4-14A

Bolt

**

JB

12/07/06

Location

Loc Qty

Loc Code

357

100

121349

100

ST357

244

120187

13

120769

1

121068

17

121444

100

121708

113

121349

May-23-12 11:32:35 AM

Shop Packet Print

Page 2

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

May-23-12 11:32:35 AM

Page 3

Work Order ID: 84806

84806

Parent Item: D206-628-012

D206-628-012

Parent Item Name: Heli-Access-Step RH

Start Date: 23/05/2012

Required Date: 06/06/2012

Start Qty: 4.00

Required Qty: 4.00

AN4-15A

Purchased

No

110

Each

591.0000

16

AN4-15A

Bolt

**

122141

JB

Location

Loc Qty

Loc Code

358

100

121652

100

GA

100

120449

100

ST358

391

118706

3

120422

88

121444

100

121541

200

AN960JD416

NAS1149D0463J

Purchased

No

110

Each

30.0000

48

AN960JD416

Washer

**

121912

JB

Location

Loc Qty

Loc Code

ST351

30

116289

10

119097

20

MS21042L4

Purchased

No

110

Each

4,414.000

48

MS21042L4

Nut

**

JB

12107/06

Location

Loc Qty

Loc Code

ST300

4414

119075

125

121011

1032

121444

2957

121652

300

121444

May-23-12 11:32:35 AM

Shop Packet Print

Page 3

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

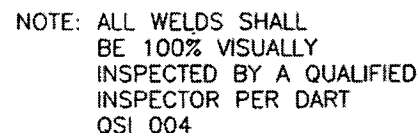
NOTE: Date & initial all entries

5.1 D206-628-011/-012/-021/-022/-031/-032 REGULAR DART HELI-ACCESS- STEPS™ PARTS LIST

Qty -011	Qty -012	Qty -021	Qty -022	Qty -031	Qty -032	Part Number	Description
X						D206-628-011	206 A/B STEP INSTALLATION LH
	X					D206-628-012	206 A/B STEP INSTALLATION RH
		X				D206-628-021	206 L/L1/L3/L4 STEP INSTALLATION LH
			X			D206-628-022	206 L/L1/L3/L4 STEP INSTALLATION RH
				X		D206-628-031	407 STEP INSTALLATION LH
					X	D206-628-032	407 STEP INSTALLATION RH
1						D2721-041	STEP ASSEMBLY LH
	1					D2721-042	STEP ASSEMBLY RH
		1		1		D2724-041	STEP ASSEMBLY LH
			1		1	D2724-042	STEP ASSEMBLY RH
				4	4	D2731-3	MOUNTING LUG
4	4	4	4			D2731-7	MOUNTING LUG
8	8	8	8	8	8	D2732-030	RUBBER CUSHION
				4	4	D3394-041	MOUNTING LUG
				4	4	*D3394-1	*MOUNTING LUG
				8	8	*MS35489-93	*GROMMET
4	4	4	4			D3394-043	MOUNTING LUG
4	4	4	4			*D3394-3	*MOUNTING LUG
8	8	8	8			*MS35489-93	*GROMMET
4	4			4	4	AN4-13A	BOLT
4	4	4	4	4	4	AN4-14A	BOLT
4	4	8	8	4	4	AN4-15A	BOLT
12	12	12	12	12	12	NAS1149D0463J	WASHER (AN960JD416)
12	12	12	12	12	12	MS21042L4	NUT (OR MS21042-4)

*DENOTES THAT PART IS INCLUDED IN ASSEMBLY ABOVE

Copyright © 2005 by DART AEROSPACE USA, INC



APPLY BLACK
ANTI-SKID ON
- TOP SURFACE
TO BOTTOM
OF TOP RADIUS

REFER TO STEP
END DETAIL

D2721-1
MAKE FROM EXTRUSION D2622-078

D2721-041 LH STEP ASSEMBLY (SHOWN)

D2721-042 RH STEP ASSEMBLY-(OPPOSITE)

ROUND CORNER OF EXTRUSION TO
MATCH BEND RADIUS OF END PLATE

Diagram of a D2734 End Plate. The diagram shows a cross-section of the end plate with a vertical dimension of 1.000 and a horizontal dimension of 45.0 degrees. The end plate is labeled "D2734 END PLATE".

QTY - Q41	QTY - Q42	PART NUMBER	DESCRIPTION
X		D2721-Q41	LH STEP ASSEMBLY
	X	D2721-Q42	RH STEP ASSEMBLY
1	1	D2622-07B	EXTRUSION
2	2	D2734	END PLATE
1	1	D3461-1	PLATE
1	1	D3461-3	PLATE
1	1	D3461-5	PLATE
		D3461-7	PLATE

TYPICAL STEP END DETAIL

- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
05.11.14 ~~16~~

DART

DESIGN		PH		DARI AEROSPACE USA, INC.		REV. C	
CHECKED		APPROVED		DRAWING NO.		SHEET 1 OF 1	
11		11		D2721			
DATE				TITLE			
05.09.19				206B STEP ASSEMBLY			
A				NEW ISSUE			
B				79" WAS 80", UPDATED WELD DETAIL REVISED TOLERANCES, 53.44 WAS 54.0			
C				RE-DESIGN, ADD D3461-1/-3/-5/-7			